

# Work Order ID 84767

May-23-12 7:38:12 AM

*See July*  
**\*84767\***

Page 1

Item ID: D2616-2 Accept **\*N900040100\*** Setup Start **\*NS1\***  
 Revision ID: Stop **\*NS2\***  
 Item Name: Mounting Lug, EC 120 Step  
 Start Date: 5/23/12 Start Qty: 40.00 **\*40\*** Cust Item ID:  
 Required Date: 6/08/12 Req'd Qty: 40.00 **\*40\*** Customer:  
 Reference:

Approvals: Process Plan: *W* Date: Tooling: Date: Run Start **\*NR1\***  
 QC: Date: SPC (Y/N): Date: Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D2616	Rev E

100	BAND SAW	0.00							
<b>*100*</b>									
Bandsaw	Memo	0.00							
Jeaspa Bandsaw	Cut blanks: 2.000" long +0.030" -0.000"								

*SL 12-06-14* *(40)*

110	HAAS CNC VERTICAL MACHINING #1	0.00							
<b>*110*</b>									
HAAS 1	Memo	0.00							
HAAS CNC vertical machine #1	1-Machine as per folio D2616-2 & DWG D2616 2-Tumble & Deburr								

*29 12-6-18* *(x40)*

120	QC2- Inspect parts off machine FAI/FAIB	0.00							
<b>*120*</b>									
QC	Memo	0.00							
Quality Control									

*29 12-6-18* *(x40)*

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 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	QC8- Inspect parts - second check	0.00	SL	12-06-20					
<b>*130*</b>									
QC	Memo	0.00							
Quality Control									
140	Chemical Conversion Coat per QSI005 4.1	0.00							
<b>*140*</b>									
HandFinish	Memo	0.00							
Hand Finishing									
150	Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3	0.00							
<b>*150*</b>									
Powdercoat	Memo	0.00							
Powder Coating	Note:Mask large holeSTART TIME: TEMPERATURE: 3200F FINISH TIME: 9:30								

40 7/12/20

40X 12/06/21

M121279

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May-23-12 7:38:12 AM

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Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	QC3- Inspect Part Finish	0.00							
<b>*160*</b>									
QC	Memo	0.00							
Quality Control									
170		0.00							
<b>*170*</b>	Small Fab								
Small Fab	Memo	0.00							
Small Fab	1-Coat bearing in light oil2-Press Bearing in D2616-23-Stack as per Dwg D2616 using DT8019 4- Touch up paint if required								
180	QC5- Inspect part completeness to step on W/O	0.00							
<b>*180*</b>									
QC	Memo	0.00							
Quality Control									

40  $\phi$  B10-601.

40  $\phi$  FF 12-06-26

cont  
(40)

5/17/04/27

**\*84767\***

May-23-12 7:38:12 AM

**Accept**

**\*N900040100\***

Setup Start \*NS1\*

Stop \*NS2\*

**Item Name:** Mounting Lug, EC 120 Step

**Start Date:** 5/23/12      **Start Qty:** 40.00

**\*40\***

**Cust Item ID:****Required Date: 6/08/12**      **Req'd Qty: 40.00**

**\*40\***

**Customer:**

**Reference:**

Run Start \*NR1\*

**Approvals:** \_\_\_\_\_ **Process Plan:** \_\_\_\_\_ **Date:** \_\_\_\_\_ **Tooling:** \_\_\_\_\_ **Date:** \_\_\_\_\_

Stop \*NR2\*

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

## Operation Description

## Set Up/ Run Hours

## Tool ID

### Tool #

## Plan Code

**Accept Qty**

Reject  
QtyReject  
Number

**Insp.  
Stamp**

190

Identify as per dwg & Stock Location: S1 Set 0.00

0.00

\*190\*

### Packaging

## Memo

0.00

## Packaging

200

QC21- Final Inspection - Work Order Release

0.00

**\*200\***


QC

## Memo

0.00

## Quality Control

40v \_\_\_\_\_ 80  
12-6-27

12/6/29 

MLF  
12-06-29

## May-23-12 7:38:12 AM

**Required Qty: 40.00**

**Comments:** IPP Rev:C00.06.22Removed P/O for powder coatEC  
IPP Rev:D 08-01-07 rev E as per dwg ECN1069 DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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40

40

FF 12-06-26

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
ST012	89	
79867	29	
<u>84057</u>	40	
84434	20	

M6061T6B1.000X02.000	Purchased	No	f	22.7480
6061-T6 Bar 1.00 x 2.00				

## 6.6

2L <sup>6.64</sup> 12-06-11

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
MAT	22.748	
112567	0	
121660	22.748	

122081

not in computer

6-65

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b> 84767
<b>Description:</b> Mounting Lug		<b>Part Number:</b> D2616-2
<b>Inspection Dwg:</b> D2616	<b>Rev:</b> D3	<b>Page 1 of 1</b>

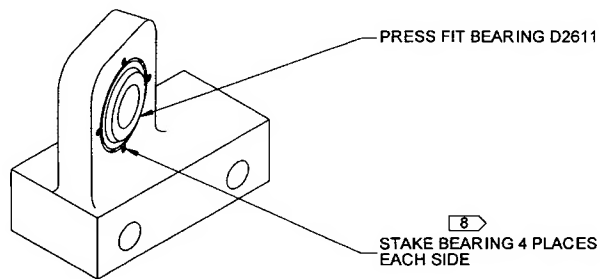
### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

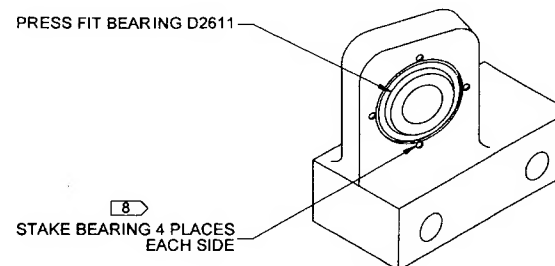
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.250	+/-0.010	.250	/		PR 22	
1.250	+/-0.010	1.250	/			
0.375	+/-0.010	.377	/			
0.625	+/-0.010	.615	/			
Ø0.257	+0.006/-0.001	.257	/			
1.000	+/-0.010	.997	/			
2.000	+/-0.010	2.003	/			
1.125	+/-0.010	1.125	/			
0.313	+/-0.010	.314	/			
17°	+/-0.5°	17°	/			
1.259	+/-0.010	1.254	/			
Ø0.625	+0.008/-0.001	.630	/			
R0.250	+/-0.010	.250	/			
R0.063	+/-0.010	.063	/			
Ø0.8115- Ø0.8120	N/A	.8115	/			

<b>Measured by:</b> [Signature]	<b>Audited by:</b> SL	<b>Prototype Approval:</b>	N/A
<b>Date:</b> 12-6-18	<b>Date:</b> 12-06-20	<b>Date:</b>	N/A

Rev	Date	Change	Revised by	Approved
A	06.09.19	New Issue	KJ/JLM	[Signature]



**D2616-1 FWD MOUNT LUG**



**D2616-2 FWD MOUNT LUG**

QTY -1	QTY -2	PART NUMBER	DESCRIPTION
X		D2616-1	FWD MOUNT LUG
	X	D2616-2	FWD MOUNT LUG
1	1	D2611	BEARING
1		D2616-1A	LUG
	1	D2616-2A	LUG

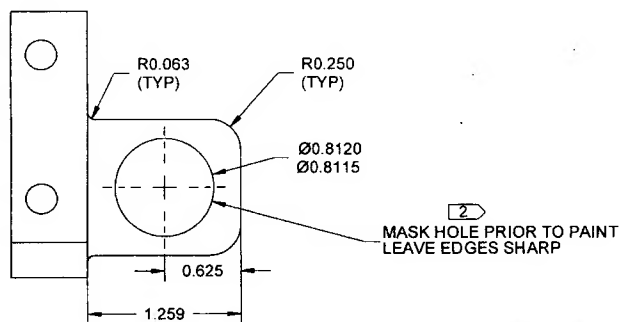
**NOTES:**

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D2616-1/-2" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.18 lbs
- 8) D2611 BEARING MUST BE STAKED TO PREVENT TRANSLATION BUT TO ALLOW ROTATION USING DT8019. TOUCH UP PAINT AFTER STAKING.

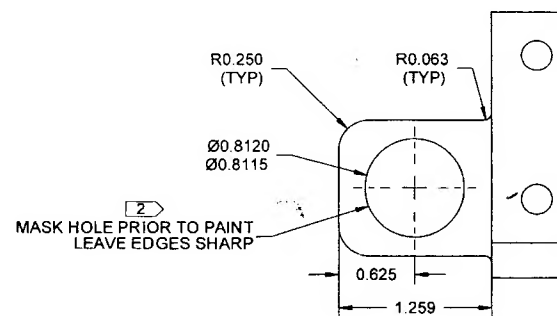
*Wb 84767*

**RELEASED**  
07.12.12 / W

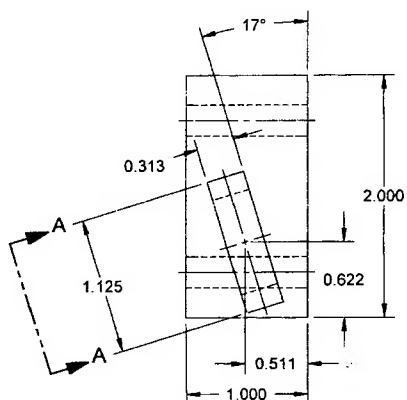
E	UPDATE DWG. SHOW 4 STAKES INSTEAD OF 8 INCORPORATE HAND CHANGES	DC	07.11.22
D	D2611 WAS CBA-6-B2	KE	97.07.31
C	REMOVE D2616-3	BW	97.06.04
B	RE-DESIGN	KE	97.05.06
A	ORIGINAL ISSUE	BW	96.10.20
REV.	DESCRIPTION	BY	DATE
DESIGN	BW	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	DC		
CHECKED	KE	DRAWING NO.	REV. E
MFG. APPR.	W	<b>D2616</b>	SHEET 1 OF 2
APPROVED	W	TITLE	SCALE
DE APPR.	W	<b>FWD MOUNT LUG</b>	1:1
DATE	07.11.22	COPYRIGHT © 1996 BY DART AEROSPACE LTD <small>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	



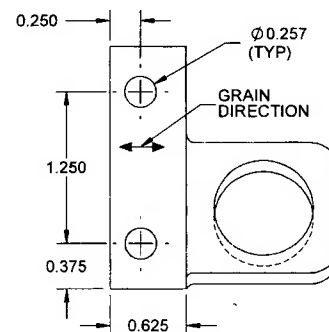
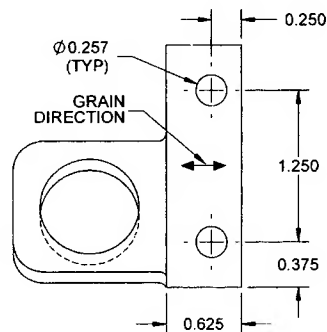
VIEW A-A



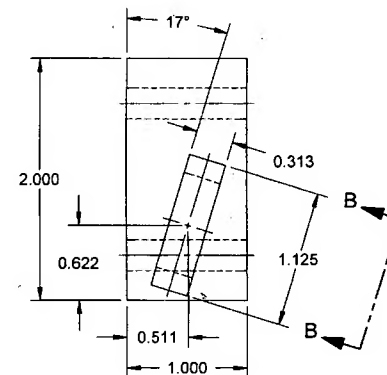
VIEW B-B



D2616-1A LUG



D2616-2A LUG



NOTES:

- 1) MATERIAL: 6061-T6 (OR 6061-T651/T6510/T6511/T62) ALUMINUM BAR  
PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116)  
OR AMS-QQ-A-200/8 (OR AMS 4160)  
(REF. DART SPEC. M6061T6B)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
MASK BEARING HOLE PRIOR TO PAINT  
POWDER COAT GREY SANDTEX (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.010 TO 0.020 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.14 lbs

RELEASED  
01-12-12

DESIGN	BW	DART AEROSPACE LTD	
DRAWN	JC	HAWKESBURY, ONTARIO, CANADA	
CHECKED	JE	DRAWING NO.	REV. E
MFG. APPR.	JE	D2616	SHEET 2 OF 2
APPROVED	JE	TITLE	SCALE
DE APPR.	JE	FWD MOUNT LUG	1:1
DATE	07.11.22	COPYRIGHT © 1996 BY DART AEROSPACE LTD	
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